

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024373**Date Inspected:** 02-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Shi Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) – NWIT Document No's: 009336

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 13AWand BW. The weld designations reviewed are as follows:

1. SEG3013C-043,044,049,050,055,056,061,062,081,082,088,089
2. BP3057-001-001~012

OBG Trial Assembly Yard

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SA3134-005, 006, 008 located on plate connected SA3134 at panel point 121 to 121.5 FL3 side of OBG Segment 13BW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

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Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014D-121, 122, 123, 124 located on floor beam to side plate at panel point 121.5 CW Side of OBG Segment 13BW. ZPMC Welder is identified as 067947. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2113-FCM-1.

FCAW welding of weld joint SEG3014S-034 located on vertical plate RS stiffener to floor beam at panel point 120.5 CW Side of OBG Segment 13BW. ZPMC Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

SMAW welding of weld joint SEG3015H-198, 199 located on floor beam to side plate at panel point 123 CW Side of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2113-FCM-1.

FCAW welding of weld joint SEG3014S-071 located on K plate RS stiffener to Floor Beam at panel point 121 of OBG Segment 13BW. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

FCAW welding of weld joint SEG3015H-267 located on side plate RS stiffener to Floor Beam at panel point 123 of OBG Segment 13CW. ZPMC Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
